

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029001**Date Inspected:** 18-Jan-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** See below.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Quality Assurance Inspector (QA) Fritz Belford was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

Welder Wai Kit Lai #2953:

Welder was observed welding fillet welds and PJP welds for the OBG Retro Stiffeners at 13E PP119-ERS-7 thru 9.

The stiffeners mentioned above are the CCO 238 Retro Stiffeners to the "C" side plating. Welder was observed preheating and using Welding Procedure Specification (WPS) ABF-WPS-D15-F2200-2 for the fillet welds and ABF-WPS-D15-2170-3 for the partial joint penetration or PJP welds. Welding parameters were verified by QC Inspector John Hays throughout the day and appear to be in compliance with the both WPSs noted above.

Welder Mike Jimenez #4671:

Welder was observed welding fillet welds and PJP welds for the OBG Retro Stiffeners at 13E PP119-ERS-4 thru 6.

The stiffeners mentioned above are the CCO 238 Retro Stiffeners to the "C" side plating. Welder was observed preheating and using Welding Procedure Specification (WPS) ABF-WPS-D15-F2200-2 for the fillet welds and ABF-WPS-D15-2170-3 for the partial joint penetration or PJP welds. Welding parameters were verified by QC Inspector Fred Michaels throughout the day and appear to be in compliance with the both WPSs noted above.

Welder Richard Garcia #5892:

Welder was observed fitting the deck access hole plate for 14E PP126.5 E2.0-DAH. Welder was observed beveling the plate and the deck opening to the required angle. No welding was done this day by the welder.

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Welder Rick Clayborn #2773:

Welder was observed fitting the CCO 238 OBG Retro Stiffeners at 13W PP119-WRS. The welder was observed using Welding Procedure Specification (WPS) ABF-WPS-D15-F2200-2 to tack weld the stiffeners in place. It is the understanding of this QA that welder Rick Clayborn will only fit the stiffeners and move on to another location.

Welding of stiffeners will be done by other qualified welders. Welding parameters were verified by QC Inspector Salvador Merino appear to be in compliance with the WPS noted above.

Non-Destructive Testing (NDT)

This QA performed Visual, Magnetic Particle and Hardness Testing on the following:

Weld 12W PP109.5 W2.0-DAH:

- o Face "A" VT and MPT Accept.

Weld 12E PP109.5 E2.0-DAH:

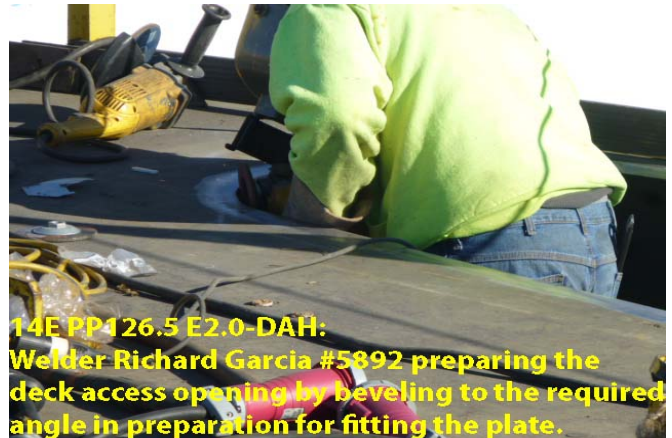
- o Face "A" VT and MPT Accept.

Weld 2W PP13.5 W2.0-DAH:

- o Hardness Testing at 4 locations.

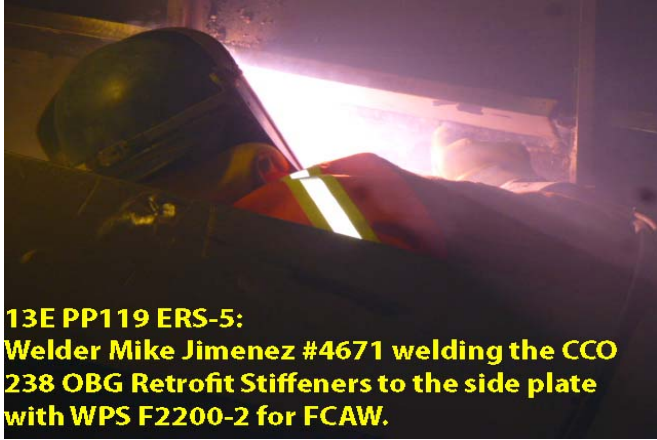
This QA Inspector completed report form TL-6028 on this date noting items acceptance or rejection as per applicable code. The completed and accepted work observed at this location appeared to be in compliance with the contract specifications.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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**13E PP119 ERS-5:
Welder Mike Jimenez #4671 welding the CCO
238 OBG Retrofit Stiffeners to the side plate
with WPS F2200-2 for FCAW.**

Summary of Conversations:

Conversations this day as required for scope of work.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas - (916) 764 - 6027, who represents the Office of Structural Materials for your project.

Inspected By:	Belford,Fritz	Quality Assurance Inspector
Reviewed By:	Reyes,Danny	QA Reviewer
